

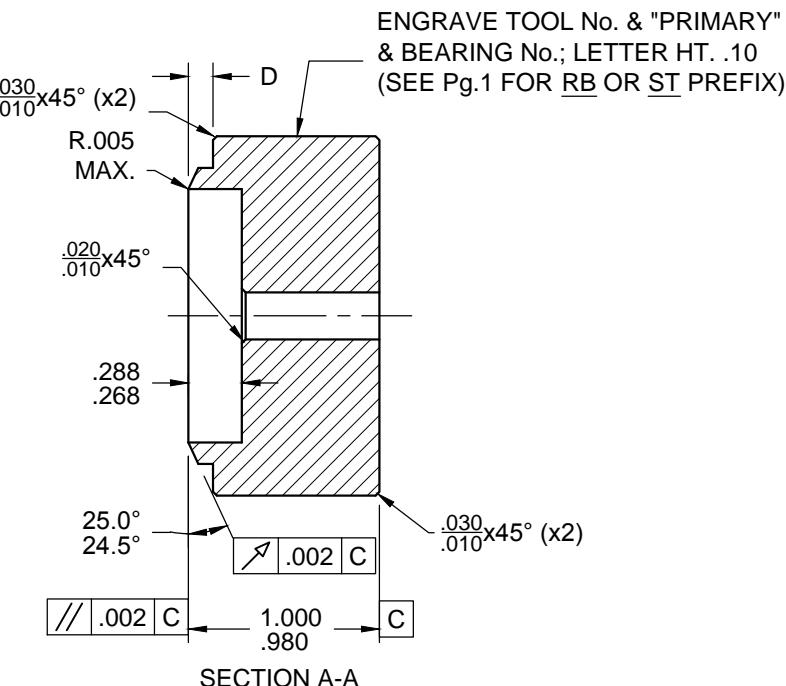
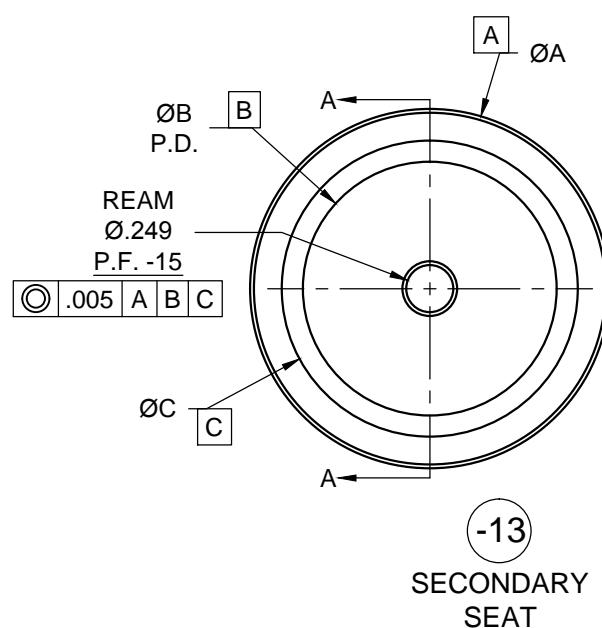
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NOTES

- ### 1. BREAK ALL SHARP CORNERS (.015/.03).

 RED BARN MACHINE	
TITLE	RBST2300 SERIES SWAGING TOOL; LOCATING PIN
DWG NO.	TOOL# (see chart)-15
REV 3	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS $.XXX \pm .005$ FRACTIONS $\pm 1/32$ $XX \pm .01$ ANGLES $\pm 5^\circ$ $X \pm .1$	
DRAWN BY: PERRITT APPROVED HEAT TREAT FINISH SPEC BLACK OXIDE USED ON BEARING SEE Pg. 1	
SCALE	NTS
DATE	6-27-08
SHEET 9 of 9	

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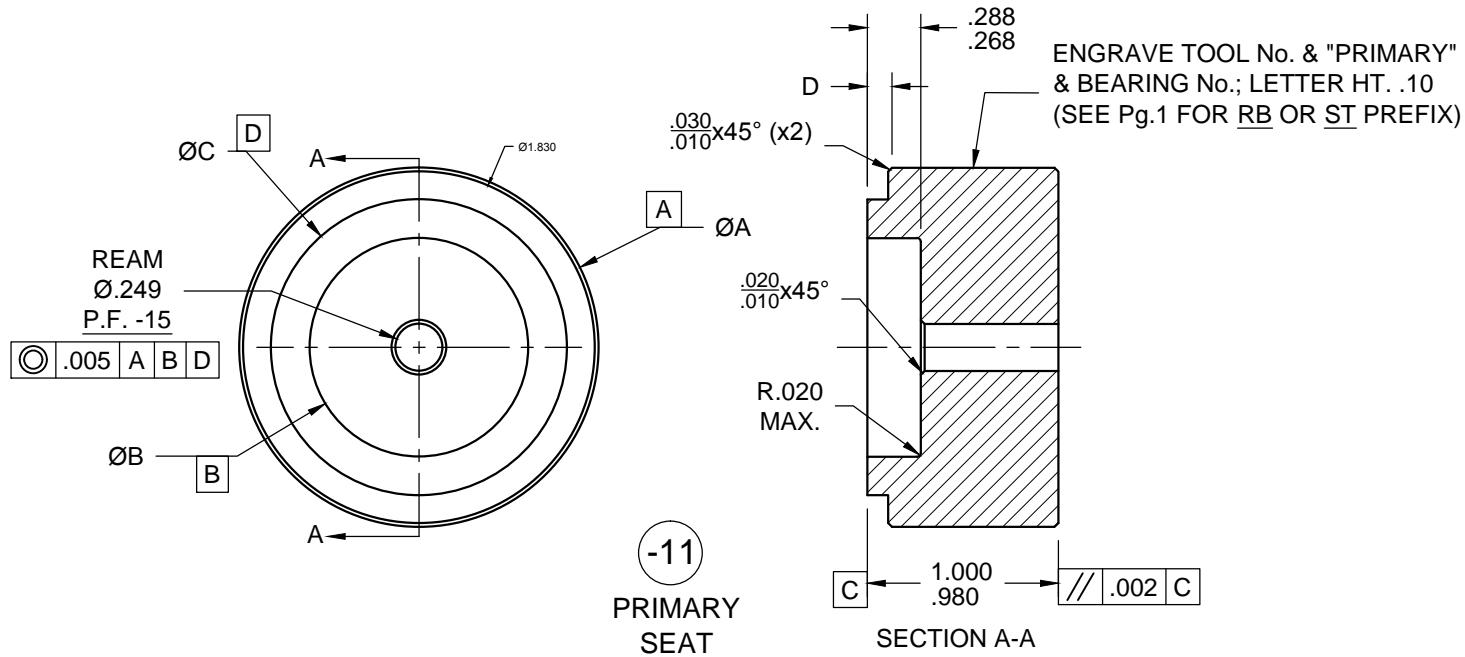


NOTES

- #### 1. BREAK ALL SHARP CORNERS (.015/.03).

 RED BARN MACHINE	
TITLE	RBST2300 SERIES SWAGING TOOL; SECONDARY SEAT
DWG NO.	TOOL# (see chart)-13
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS	
.XXX ± .005	FRACTIONS ± 1/32
XX ± .01	ANGLES ± 5°
X ± .1	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR. .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
DRAWN BY: PERRITT	
APPROVED	
HEAT TREAT	
FINISH SPEC BLACK OXIDE	
USED ON BEARING	
SEE Pg. 1	
SCALE	NTS
DATE	6-27-08
SHEET 8 of 9	

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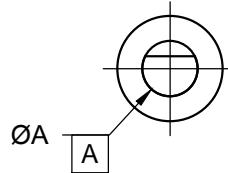


NOTES

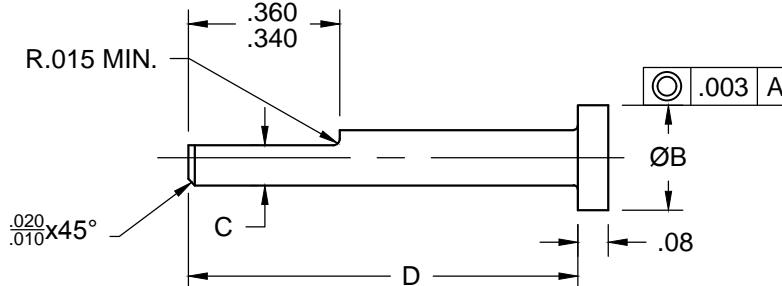
- ### **1. BREAK ALL SHARP CORNERS (.015/.03).**

 RED BARN MACHINE	
TITLE	RBST2300 SERIES SWAGING TOOL; PRIMARY SEAT
DWG NO.	TOOL# (see chart)-11
REV 3	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS	
.XXX ± .005	FRACTIONS ± 1/32
XX ± .01	ANGLES ± .5°
X ± .1	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 X 45° PR. .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
DRAWN BY: PERRITT	
APPROVED	
HEAT TREAT	
FINISH SPEC BLACK OXIDE	
USED ON BEARING	
SEE Pg. 1	
SCALE	NTS
DATE	6-27-08
SHEET 7 of 9	

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-9
PIN

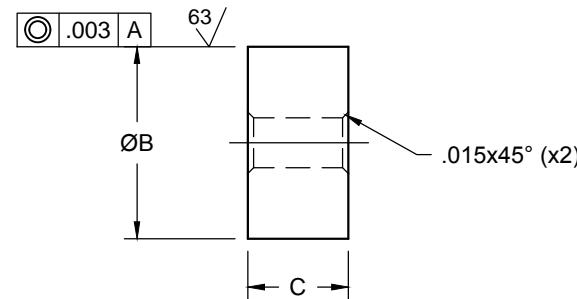
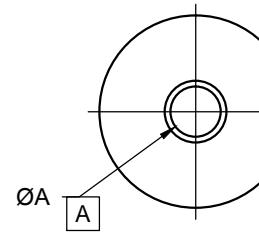


NOTES

- #### 1. BREAK ALL SHARP CORNERS (.015/.03).

RB		RED BARN MACHINE	
TITLE		RBST2300 SERIES SWAGING TOOL; PIN	
DWG NO.		TOOL# (see chart)-9	
		REV 3	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS $.XXX \pm .005$ $.XX \pm .01$ $X \pm .1$		DRAWN BY: PERRITT APPROVED HEAT TREAT FINISH SPEC BLACK OXIDE USED ON BEARING SEE Pg. 1	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES $.015 \times .45^\circ$ PR. 015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING			
SCALE	NTS	DATE	6-27-08
		SHEET	6 of 9

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-7

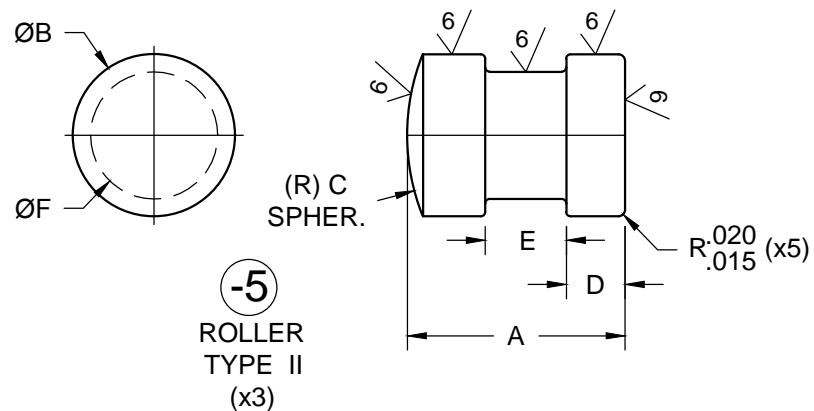
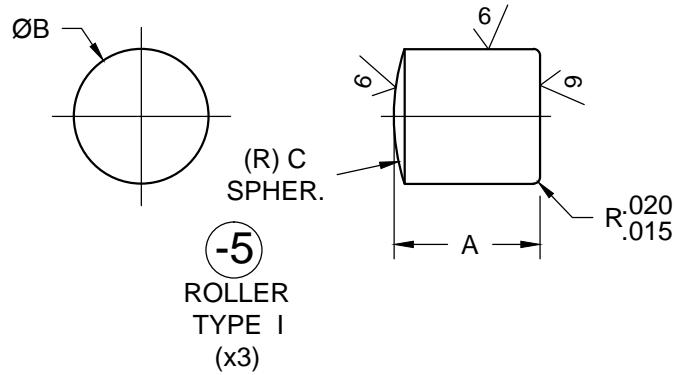
GUIDE

NOTES

- ## 1. BREAK ALL SHARP CORNERS (.015/.03).

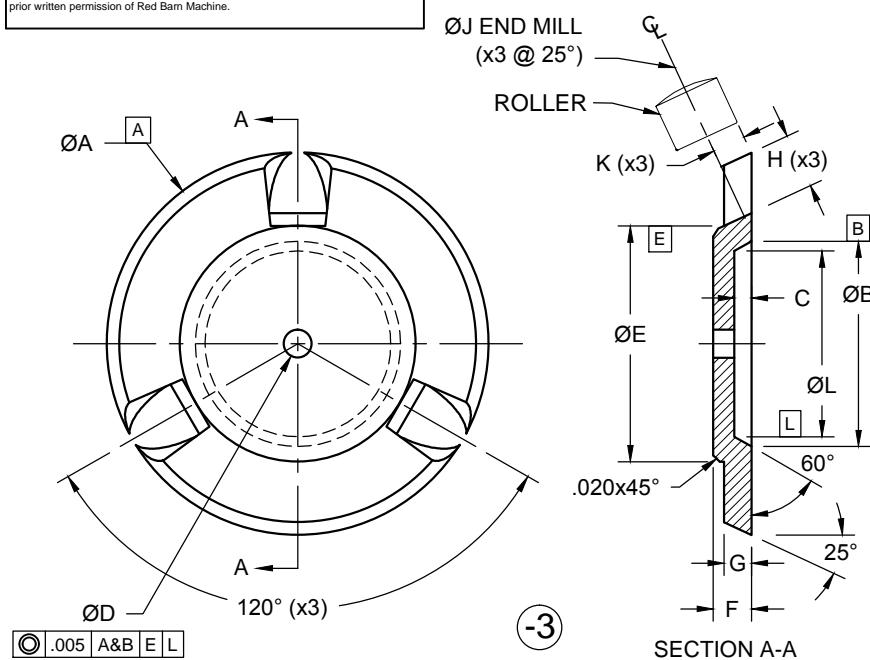
 RED BARN MACHINE	
TITLE	RBST2300 SERIES SWAGING TOOL; GUIDE
DWG NO.	TOOL# (see chart)-7
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1	
FRACTIONS ± 1/32 ANGLES ± .5°	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 X 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
DRAWN BY: PERRITT APPROVED HEAT TREAT FINISH SPEC USED ON BEARING SEE Pg. 1	
SCALE	NTS DATE 6-27-08 SHEET 5 of 9

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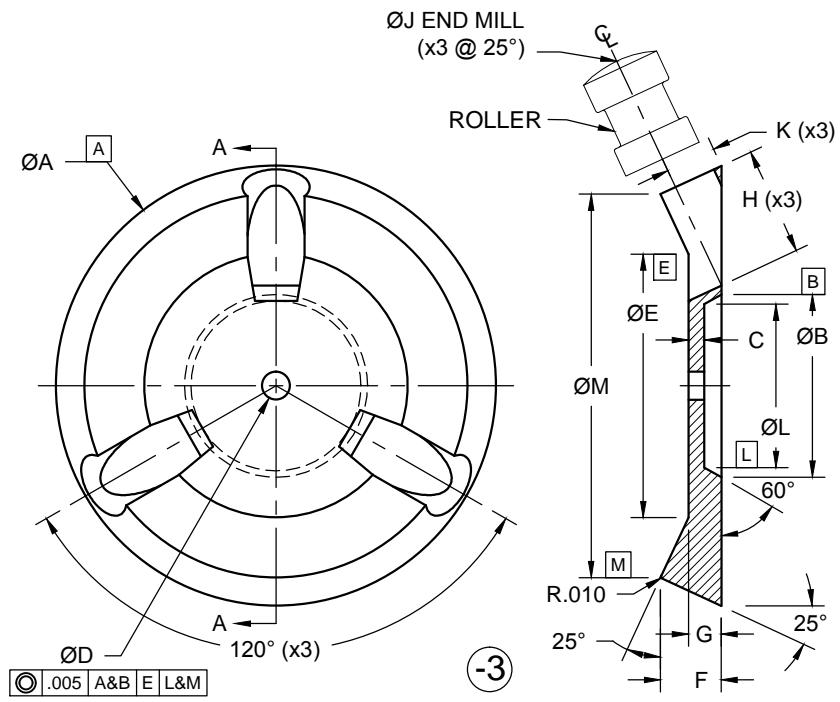


 RED BARN MACHINE		
TITLE	RBST2300 SERIES	
SWAGING TOOL; ROLLER (QTY. 3)		
DWG NO.	TOOL# (see chart)-5	
		REV 3
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS $.XXX \pm .005$ FRACTIONS $\pm 1/32$ $.XX \pm .01$ ANGLES $\pm .5^\circ$ $X \pm .1$		DRAWN BY: PERRITT APPROVED HEAT TREAT FINISH SPEC
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES $.015 \times 45^\circ$ PR. $.015$ R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING		USED ON BEARING SEE Pg. 1
SCALE	NTS	DATE 6-27-08 SHEET 4 of 9

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RETAINER TYPE I



RETAINER TYPE II

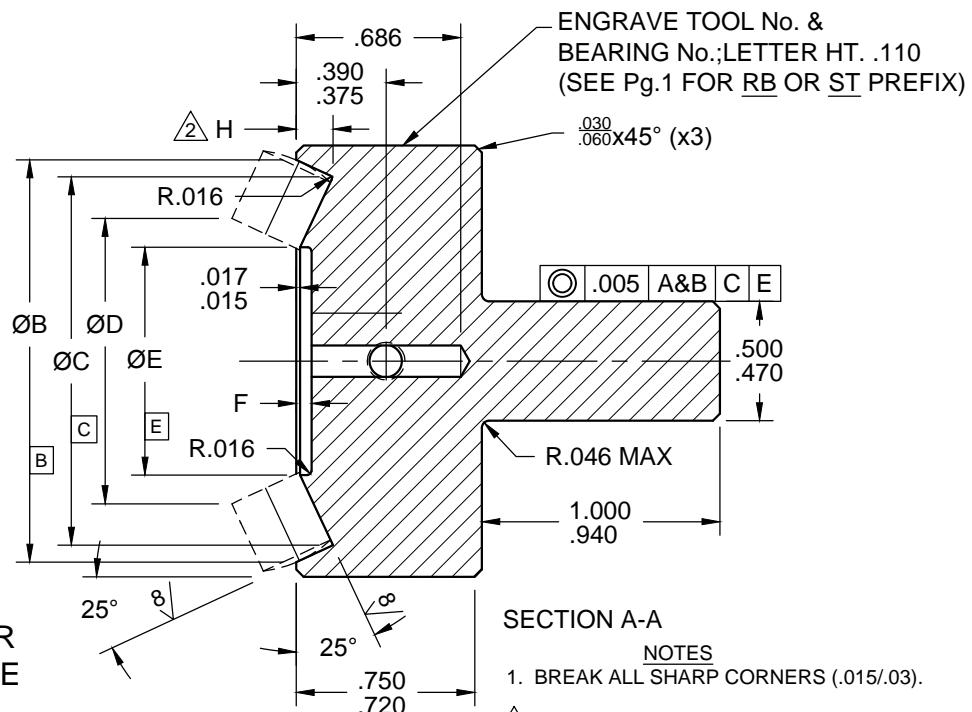
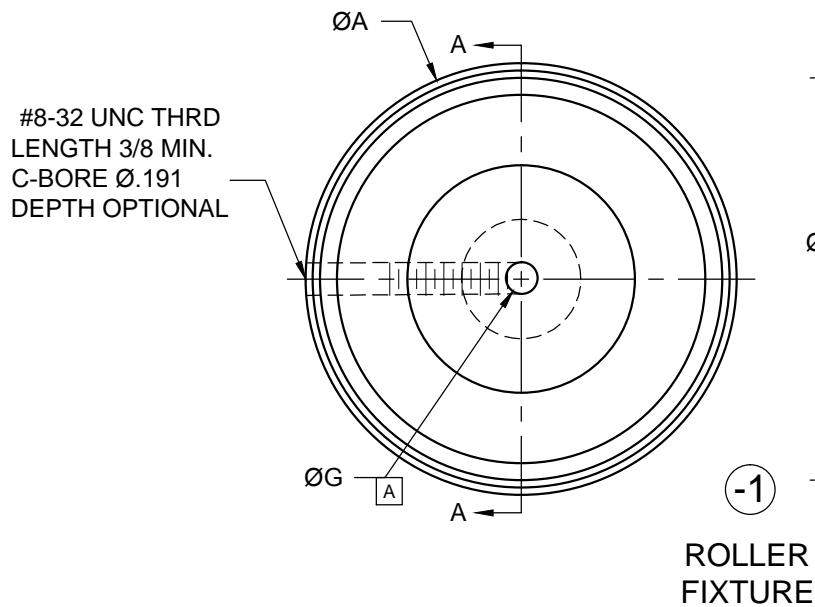
NOTES

- #### 1. BREAK ALL SHARP CORNERS (.015/.03).

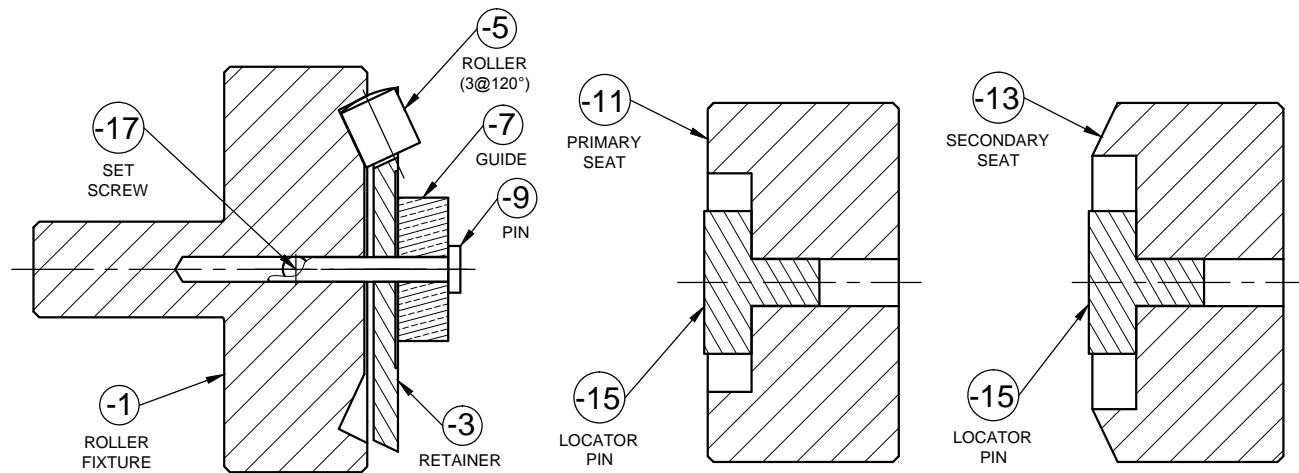
 RED BARN MACHINE	
TITLE	RBST2300 SERIES SWAGING TOOL; RETAINER
DWG NO.	T- <u>TOOL#</u> (see chart)-3
REV 3	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS	
.XXX ± .005	FRACTIONS ± 1/32
.XX ± .01	ANGLES ± 5°
X ± .1	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
DRAWN BY: PERRITT APPROVED HEAT TREAT FINISH SPEC	
USED ON BEARING SEE Pg. 1	
SCALE	NTS
DATE	6-27-08
SHEET 3 of 9	

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
3	-1 CH'D TOL.(H) WAS +/- .002 IS +/- .005.	6/17/13	BIM	GE



REV		DESCRIPTION		DATE	INITIAL	APPROVED
1		CHANGED -5 ROLLER RADUIS FROM .005 -.010, TO .015 -.020; AND -9 PIN RADIUS FROM .015 MAX., TO .015 MIN. ALSO CHANGED -7 SLEEVE TO -7 GUIDE.		7/7/08	WP	DW
2		ADDED ST2345 INFORMATION, CHANGED -9 FLAT FROM .375-.400, CHANGED -11 & -13 CENTER DEPTH FROM .228, AND REMOVED "K" FROM ALL TOOL No.'S WITH ENGRAVING NOTES TO CHECK FIRST PAGE FOR PREFIX TO TOOL No.		11/19/08	WP	DW
2A		CH'D T/N FROM ST.		11/19/09	RJC	
3		-1 CH'D TOL.(H) WAS +/- .002 IS +/- .005.		6/17/13	BIM	GE



BEARINGS & TOOLS COVERED	
BEARING #	TOOL #
412-310-400-107	RBST2345
412-310-400-107	RBST2345
S251W125-5, CAS12-31A1-518	RBST2369
S251W125-5, CAS12-31A1-518	RBST2369

NOTES

- 5 ROLLERS MUST TURN FREELY IN -3 RETAINER POCKETS.
- 5 ROLLERS & -3 RETAINER MUST TURN FREELY WHEN TOOL IS COMPLETELY ASSEMBLED.
- FLAT END OF ROLLERS MUST FACE TOWARDS THE CENTER OF THE TOOL WHEN ASSEMBLED.

ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	B/O INFORMATION OR SPECIFICATIONS	Pg.
		-1	1	ROLLER FIXTURE	SEE CHART	2
		-3	1	RETAINER	SEE CHART	3
		-5	3	ROLLER	SEE CHART	4
		-7	1	GUIDE	SEE CHART	5
		-9	1	PIN	SEE CHART	6
		-11	1	PRIMARY SEAT	SEE CHART	7
		-13	0 or 1	SECONDARY SEAT	SEE CHART	8
		-15	1 or 2	LOCATING PIN	SEE CHART	9
	B/O	-17	1	SOCKET HEAD SET SCREW	#8-32 x 1/4	N/S

TITLE RB RED BARN MACHINE	
DWG NO. RBST2300 SERIES	
TRI-ROLLER SWAGING TOOLS	
TOOL # (SEE CHART ABOVE)	
REV 3	
UNLESS OTHERWISE SPECIFIED	
DIMENSIONS ARE IN INCHES	
TOLERANCES ON:	
DECIMALS	
XXX \pm .005	FRACTIONS \pm 1/32
XX \pm .01	ANGLES \pm 5°
X \pm .1	
UNLESS OTHERWISE SPECIFIED	
1. BREAK ALL SHARP EDGES	
.015 x 45° PR.015 R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
DRAWN BY: PERRITT	
APPROVED	
HEAT TREAT LISTED PER ITEM	
FINISH SPEC LISTED PER ITEM	
USED ON BEARING	
SEE ABOVE	
SCALE	NTS
DATE	6-27-08
SHEET 1 of 9	

REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPR
—	—	—	—	—

NOT APPROVED FOR PRODUCTION

REVISIONS			
REV	DESCRIPTION	DATE	APPROVED

PART #	QTY	DESCRIPTION
-1	1	--

DRAWN BY: PERRITT	RB RED BARN MACHINE
CHECKED	
HEAT	
TREAT	
FINISH SPEC	
USED ON MODEL	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
?	TOLERANCES ON: DECIMALS .XXX ± .005 FRACTIONS ± 1/32 .XX ± .01 ANGLES ± 5°
	UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES 0.015 x 45° PR. 0.015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING
	DWG NO.
	SCALE NTS DATE 1-28-06 SHEET 1 of 1